

Del 1.25 Work Order ID 73326

Wednesday, August 31, 2011 11:00:59 AM



Page 1

Item ID: D3417-5

Accept



Setup Start



Revision ID:

Item Name: Washer

Stop



Start Date: 9/1/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: 11-09-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev E

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA761

Rev: *MF* &

Dwg D3417 Rev: *E*

2-Deburr

SL 11-09-29

41

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11-09-29

41

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 11-09-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73326

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 053

0.00



Packaging

Memo

0.00

Packaging

Rec'd 10/3 (41)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/5

mf 11-10-4

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 11:00:54 AM

Page 1

Work Order ID: 73326



Parent Item: D3417-5



Parent Item Name: Washer

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A ☐ New issue ☐ 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINR1.2500

Purchased

No

110

f

14.4680

0.0296

1.246316



SA 09/29

DELRIN ROUND BAR 1.25"

Location

MAT055

114586

Loc Qty

14.468

14.468

Loc Code

1.5/Pl

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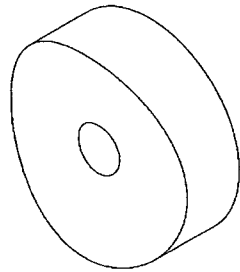
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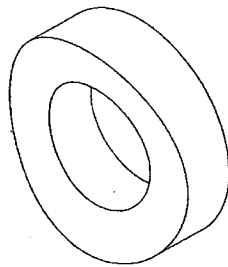
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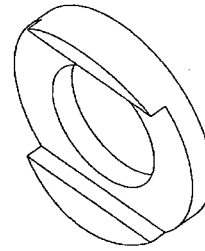
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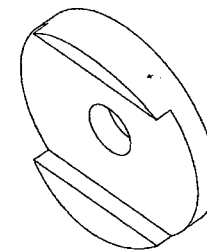
D3417-1 WASHER



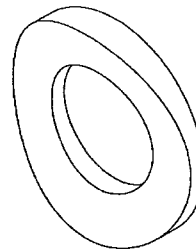
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

RELEASED
2010-09-15

73306

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELRIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELRIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

REV.	DESCRIPTION	BY	DATE
F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3417 TITLE WASHER SCALE NTS SHEET 1 OF 3 REV. F DATE 10.07.26	
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			

8 7 6 5 4 3 2 1

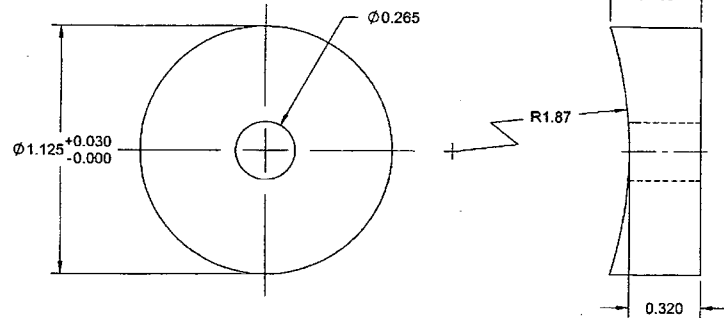
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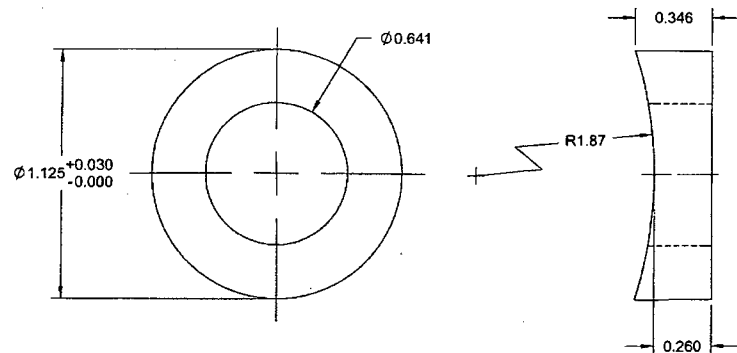
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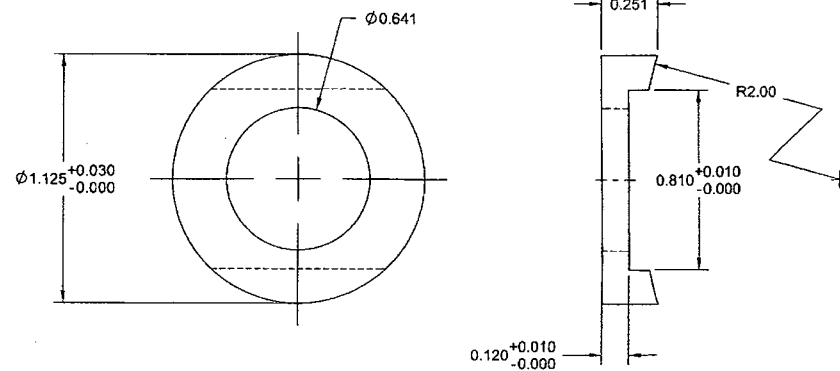
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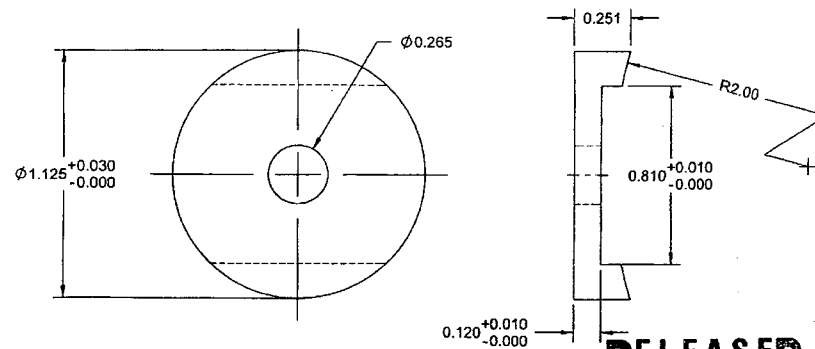
D3417-1 WASHER



D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

73326

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

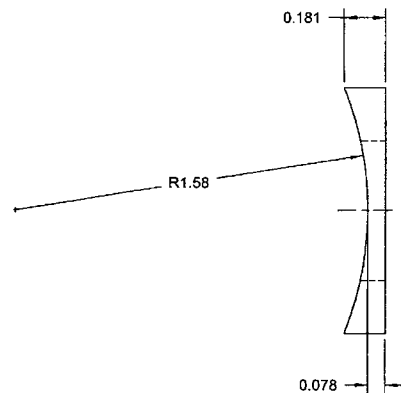
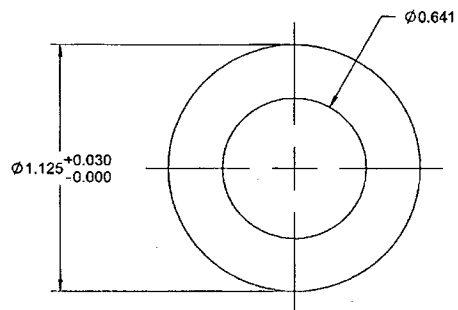
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D3417-9 WASHER

73324

RELEASED
2010-09-15
MD

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DRAWN	SC		
CHECKED		DRAWING NO. D3417	REV. F
MFG. APPR.		SHEET 3 OF 3	
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